

**WHAT IS CLAIMED IS:**

1           1. A method of making a fabric on a double bar knitting machine, with the fabric  
2     having a technical face with a velour surface and a first set of appearance characteristics, and  
3     the fabric having an opposite, technical back with a velvet surface and a second set of  
4     appearance characteristics, the first set of appearance characteristics of the technical face  
5     contrasting to the second set of appearance characteristics of the technical back, said method  
6     comprising the steps of:

7           selecting backing or stitch yarns and selecting pile yarns to provide the fabric with the  
8     technical face having the first set of appearance characteristics and the technical back having  
9     the contrasting second set of appearance characteristics,

10           the first set of appearance characteristics of the technical face selected from  
11     among: depth of color upon dyeing, degree of raising, degree of air permeability,  
12     susceptibility to selected dye formulation, reaction to heat, and degree of coarseness, bulk  
13     and/or denier; and

14           the second set of contrasting appearance characteristics selected from among:  
15     depth of color upon dyeing, degree of fiber straightness, degree of fiber curl, degree of fiber  
16     shrinkage, degree of fiber crimp degree of raising, reaction to heat, degree of yarn  
17     coarseness, bulk and/or denier;

18           knitting a three-dimensional fabric structure on the knitting machine, said structure  
19     having two fabric substrates formed from the backing and stitch yarns, each defining a  
20     technical face and a technical back, and a plurality of the pile yarns extending between and  
21     interconnecting the fabric substrates;

22           during knitting, causing the backing yarns or the stitch yarns to cover the pile yarns at  
23     the technical face of each fabric substrate;

24           cutting the pile yarns to separate the fabric substrates, with ends of the pile yarns  
25     extending from the technical back of each fabric substrate;

26           dyeing the fabric substrate;

27           processing the backing yarns or the stitch yarns covering the pile yarns at the  
28     technical face of the fabric substrate to form the velour surface; and

29           processing the pile yarns at the technical back of the fabric substrate to form the  
30     velvet surface.

1           2. The method of making a fabric of claim 1, wherein the step of dyeing the fabric  
2 comprises dyeing to a solid color, and the step of selecting the yarns comprises selecting the  
3 yarns to have different dyeabilities and/or dye uptakes.

1           3. The method of making a fabric of claim 1 or 2, wherein the step of dyeing the  
2 fabric substrate comprises:  
3           dyeing the backing yarns or stitch yarns exposed at the technical face to have a first  
4 base color and a first depth of color, and  
5           dyeing the pile yarns exposed at the technical back to have a first base color and a  
6 second depth of color, said first depth of color being in contrast to said second depth of color.

1           4. The method of making a fabric of claim 3, wherein the step of selecting the first set  
2 of appearance characteristics and selecting the contrasting second set of appearance  
3 characteristics comprises selecting the depth of color upon dyeing, with the first depth of  
4 color selected to be relatively lighter than the second depth of color.

1           5. The method of making a fabric of claim 3, wherein the step of selecting the first set  
2 of appearance characteristics and selecting the contrasting second set of appearance  
3 characteristics comprises selecting the depth of color upon dyeing, with the first depth of  
4 color selected to be relatively darker than the second depth of color.

1           6. The method of making a fabric of claim 4, wherein the step of selecting the first set  
2 of appearance characteristics and selecting the contrasting second set of appearance  
3 characteristics comprises selecting a first dye for the backing or stitch yarns and selecting a  
4 second, different dye for the pile yarns.

1           7. The method of making a fabric of claim 4, wherein the step of selecting the first set  
2 of appearance characteristics and selecting the contrasting second set of appearance  
3 characteristics comprises selecting a first material for the backing or stitch yarns and  
4 selecting a second material for the pile yarns.

1           8. The method of making a fabric of claim 7, wherein the step of selecting the  
2 backing or stitch yarns and selecting the pile yarns comprises selecting the first material and  
3 the second material to be 100% polyester.

1           9. The method of making a fabric of claim 5, wherein the step of selecting the first set  
2 of appearance characteristics and selecting the contrasting second set of appearance  
3 characteristics comprises selecting a first dye for the backing or stitch yarns and selecting a  
4 second, different dye for the pile yarns.

1           10. The method of making a fabric of claim 5, wherein the step of selecting the first  
2 set of appearance characteristics and selecting the contrasting second set of appearance  
3 characteristics comprises selecting a first material for the backing or stitch yarns and  
4 selecting a second material for the pile yarns.

1           11. The method of making a fabric of claim 9, wherein the step of selecting the  
2 backing or stitch yarns and selecting the pile yarns comprises selecting the first material and  
3 the second material to be 100% polyester.

1           12. The method of making a fabric of claim 1, wherein the step of selecting the pile  
2 yarns comprises selecting first pile yarns having first appearance characteristics and selecting  
3 second pile yarns having second appearance characteristics different from the first  
4 appearance characteristics, and the step of knitting comprises disposing the pile yarns in a  
5 predetermined pattern comprising one or more regions of the first pile yarns having the first  
6 appearance characteristics and one or more regions of the second pile yarns having the  
7 second appearance characteristics different from the first appearance characteristics.

1           13. The method of making a fabric of claim 1, wherein the step of processing the pile  
2 yarns comprises causing the velvet surface to have a depth in the range of about 2/32-inch to  
3 about 18/32-inch.

1           14. The method of claim 1, comprising the further step of dyeing one or more regions  
2 of the backing or stitch yarns at the technical face through by application of dye of  
3 contrasting color by wet printing techniques.

1           15. The method of claim 1, comprising the further step of applying a chemical binder  
2 upon one or more regions of the backing or stitch yarns at the technical face to create regions  
3 of enhanced surface abrasion resistance.

1           16. The method of claim 1, comprising the further step of applying a chemical resist  
2 upon one or more regions of the backing or stitch yarns of the technical face prior to the step  
3 of processing, for local resistance to napping and raising, thereby to create a predetermined  
4 pattern of regions of low or no fleece among adjacent regions of high fleece in the velour  
5 surface of the technical face.

1           17. A fabric comprising a plurality of backing or stitch yarns cooperatively knitted  
2 together and thereby defining a technical face with a velour surface and a first set of  
3 appearance characteristics and a technical back with a velvet face and a second set of  
4 appearance characteristics, said first set of appearance characteristics contrasting with said  
5 second set of appearance characteristics; and

6           a plurality of pile yarns extending from said technical back and being napped or  
7 raised, thereby forming the velvet surface at said technical back; and

8           said backing or stitch yarns covering said technical face and being napped or raised,  
9 thereby forming the velour surface at said technical face, said backing or stitch yarns  
10 covering said pile yarns along said technical face in a manner such that only said backing or  
11 stitch yarns are raised along said technical face;

12           said backing or stitch yarns being formed of materials having said first set of  
13 appearance characteristics selected from the group of appearance characteristics consisting  
14 of: depth of color upon dyeing, degree of raising, degree of air permeability, susceptibility to  
15 selected dye formulation, reaction to heat, and degree of coarseness, bulk and/or denier; and

16           said pile yarns being formed of materials having said second set of appearance  
17 characteristics selected from among the group of appearance characteristics consisting of:

18 depth of color upon dyeing, degree of fiber straightness, degree of fiber curl, degree of fiber  
19 shrinkage, degree of fiber crimp degree of raising, reaction to heat, degree of yarn  
20 coarseness, bulk and/or denier.

1 18. The fabric of claim 17 wherein said backing or stitch yarns covering said pile  
2 yarns on said technical face have a first cross-section and said pile yarns have a second,  
3 different cross-section.

1 19. The fabric of claim 18 wherein said pile yarns have a cross-section selected from  
2 the group consisting of serrated ribbon and trilobal.

1 20. The fabric of claim 17 wherein said backing or stitch yarns covering said pile  
2 yarns on said technical face have a first denier and said pile yarns have a second, different  
3 denier.

1 21. The fabric of claim 17 wherein said technical back and said technical face are of  
2 the same hue.

1 22. The fabric of claim 17, wherein said technical back and said technical face have  
2 contrasting surface textures.

1 23. The fabric of claim 22 wherein said technical back has a raised pile surface and  
2 said technical face has a sheared chamois or suede surface.

1 24. The fabric of claim 17 wherein said velvet surface of said technical back and said  
2 velour surface of said technical face have contrasting pile heights.

1 25. The fabric of claim 24 wherein said velvet surface of said technical back has a  
2 pile height in the range of about 0.06 inch to about 0.6 inch, and said velour surface of said  
3 technical face has a significantly lower pile height than said velvet surface of said technical  
4 back.

1           26. The fabric of claim 17 wherein said backing or stitch yarns covering said pile  
2       yarns at said technical face comprise microdenier yarns.

1           27. The fabric of claim 17 wherein said fabric is jet-dyed.

1           28. The fabric of claim 17 wherein said pile yarns comprise polyester.

1           29. The fabric of claim 17 or 28 wherein said backing or stitch yarns cover said pile  
2       yarns at said technical face comprise polyester.

1           30. The fabric of claim 17 wherein said pile yarns and said backing or stitch yarns  
2       comprise 100% polyester yarns.

1           31. The fabric of claim 17, wherein one or more regions of said velour surface at said  
2       technical face have color contrasting to a surrounding region by application of dye by wet  
3       printing techniques.

1           32. The fabric of claim 17, wherein one or more regions of said backing or stitch  
2       yarns at said technical face have enhanced surface abrasion resistance by application of  
3       chemical binder.

1           33. The fabric of claim 17, wherein said technical face defines a predetermined  
2       pattern of regions of low or no fleece among adjacent regions of high fleece in said velour  
3       surface, achieved by application of a chemical resist upon regions of said backing or stitch  
4       yarns of said technical face prior to processing, for local resistance to napping and raising.